

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-010271**Date Inspected:** 02-Nov-2009**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Mr. You qi guo**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance(QA) Inspector, Baskar Govindarajan, was present during the times noted above for observations relative to the work being performed.

**Machining area**

1.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 041271 perform SMAW repair welding on, 95.5 mtr. diaphragm, AB corner diagonal plate in west tower, Lift 3 . ZPMC CWI Identified as Mr. You qi guo. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW- 3G (3F)-repair.

2.This QA inspector, Baskar Govindarajan, observed, ZPMC qualified welding personnel identified as 052930 perform SMAW repair welding on, 65 mtr. Diaphragm, AE corner in North tower, Lift 3 .The weld joint identified as NSTL3-3 D/K-51. ZPMC CWI Identified as Mr. Tu jun. The welding parameters as measured using QC's calibrated instruments appeared to be in general compliance with WPS-345-SMAW- 2G (2F)-repair

3.This QA inspector, Baskar Govindarajan, observed, Transverse indication while doing Magnetic particle checking at machining yard on west tower, lift 3, 105.5 mtr. Diaphragm fit lug no. WSTL3- 4 H/K-85. This weld is situated in Skin D of tower. Incident report prepared.

**Magnetic Particle Testing:**

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## WELDING INSPECTION REPORT

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This QA inspector performed Magnetic Particle Testing (MT) of approximately 15% of the area previously tested and accepted by ZPMC Quality Control personnel. This QA Inspector generated a TL-6028 MT report for this date. The member is identified as west tower, Lift 3, 105.5 and 102.5 mtr. Diaphragm fit lugs and diaphragm to Skin A, B, C, D and E. The weld designations reviewed are as follows:

WSTL3-4 H/K – Jt. nos. 47,53,54,125,126,55,135 – Skin B

WSTL3-4 H/K -Jt.nos. 53,54,69,70,153,63,6,7,39,40,41 -102.5 mtr. –Skin A,C,D,E

WSTL3-4 H/K -Jt.nos. 81,82,118,119,122,139,140,142 -105.5 mtr. –Skin A,C,D,E

### Visual Inspection Testing:

This QA inspector performed Visual Inspection (VT) of 100% of the area previously tested and accepted by ZPMC Quality Control personnel. The member is identified as Skin B, south tower, Lift 1 to Base plate. The weld designations reviewed are as follows:

SSD1-A 111-B/H- Jt. nos – 18 to 25- Skin B –Stiffeners

SSD1- A 111 B/H -7, 128 – Skin B to base plate

Unless otherwise noted, all work observed on this date appeared to generally comply with applicable contract documents.

### Summary of Conversations:

No relevant conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Serge, Sinevod - 134-8257-0045, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Baskar,Govindarajan	Quality Assurance Inspector
<b>Reviewed By:</b>	Clifford,William	QA Reviewer

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